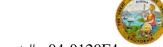
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453

(707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-022990 Address: 333 Burma Road **Date Inspected:** 23-Apr-2011

City: Oakland, CA 94607

OSM Arrival Time: 1500 **Project Name:** SAS Superstructure **OSM Departure Time:** 300 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: See Below **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** OBG

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 1

This QA inspector observed ZPMC in process of FCAW welding Bike Path Handrail sub-assemblies. ZPMC QC inspector Li Wei Lin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Tian Lei as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- Bike Path Handrail Sub-assembly WPS-B-P-2112 Welder- 054456 2F/FCAW

Bay 4

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding and heat straightening on traveler rail assemblies to correct distortion after welding. ZPMC CWI inspector Tian Lei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the

WELDING INSPECTION REPORT

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following location;

WR20795

Weld- 3025TR1-003-011

WPS-345-SMAW-1G(1F)-Repair

Welder- 068764

2G/FCAW(ESAB)/CJP

WR20794

Weld- 3025TR1-001-019

WPS-345-SMAW-1G(1F)-Repair

Welder- 068764

2G/FCAW(ESAB)/CJP

Heat Straightening

HSR1 (B) 10291

3007TR2-001, 3022TR1-001, 3010TR1-002, 3025TR1-001, 3025TR1-002, 3025TR1-003, 3023-TR1-001,

3023TR1-002, 3023TR1-003, 3009TR1-001, 3020TR1-001, 3026TR1-001

Bay 14 (14E)

UT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08913 from ZPMC for QAUT verification for segment 14E. This QA inspector performed ultrasonic test (UT) verification, after ZPMC had performed their UT inspection of the following locations.

Item 5

SEG3019D-235, 239, 244, 248, 252, 256, 264, 268, 287, 291, 295, 299, 303, 307, 311

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 04-23-2011 for additional information.

The following digital picture illustrate stiffener to floorbeam CJP weld testing.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

"As noted within the contents of this report."

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer